

# Work Order ID 86130

**\*86130\***

Page 1

Item ID: D3770-3

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Tube

Start Date: 21/06/2012 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/06/21

Tooling:

Date:

Run Start **\*NR1\***

QC: Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3770

Rev B

100

0.00

**\*100\***

Small Fab

Small Fab

Memo

0.00

Small Fab

1-cut tube to lenght as per dwg D37702-drill holes thru to finish size as per dwg D3770 Using DT94123- deburr

6 0 FF  
12-06-28

110

QC5- Inspect part completeness to step on W/O

0.00

**\*110\***

QC

Memo

0.00

Quality Control

07/06/30

(76)

120

Chemical Conversion Coat per QSI005 4.1

0.00

**\*120\***

HandFinish

Memo

0.00

Hand Finishing

6 12/06/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Work Order ID 86130

\*86130\*

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June-21-12 8:24:29 AM

Item ID: D3770-3

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Tube

Stop \*NS2\*

Start Date: 21/06/2012 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*  
Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC3- Inspect Part Finish	0.00							
*130*									
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: <i>ST 250</i>	0.00							
*140*									
Packaging	Memo	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
*150*									
QC	Memo	0.00							
Quality Control									

*12/7/3* *(6)*

*6x* *SP*  
*12-7-3*

*12/7/4*

*12-07-4*

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

June-21-12 8:24:33 AM

Page 1

Work Order ID: 86130

\*86130\*

Parent Item: D3770-3

\*D3770-3\*

Parent Item Name: Tube

Start Date: 21/06/2012

Required Date: 05/07/2012

Start Qty: 6.00

Required Qty: 6.00

## Comments:

IPP Rev:A 08-07-21 revB as per dwg DD verified by:EC

IPP Rev:B Added Drilling Tooling 08-08-27 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6T1.000W065

Purchased

No

100

f

85.9465

1.8125

11.44737

**\*M6061T6T1 000W065\***

\*\*

6061T6 RD TUBE 1.00 x .065w

⑥ 12-06-28

## Location

MAT015

114089

116720

117983

122146

## Loc Qty

85.9465469

0.3114

1.2

24.4351469

60

## Loc Code

11.44737

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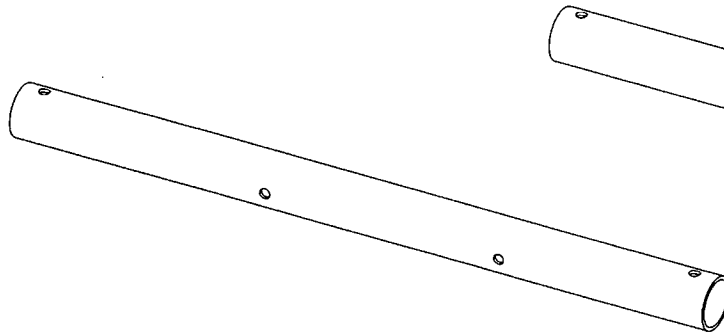
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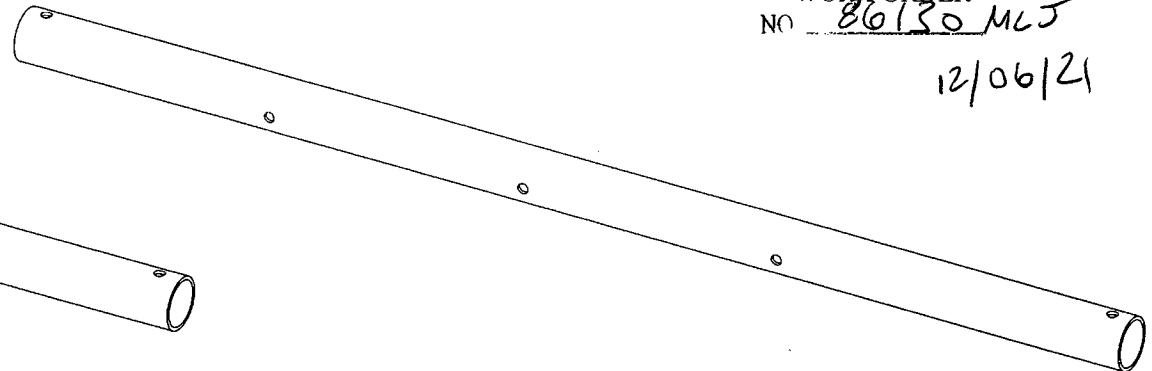
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO 86130 MJS

12/06/21



**D3770-1 TUBE**



**D3770-3 TUBE**

**NOTES:**

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" X 0.065" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3770-1, 0.25 lbs  
D3770-3, 0.40 lbs

B	CHANGE HOLES SIZE TO 0.201	HS	08.06.23
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS		
DRAWN	HS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.06.23		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3770  
TITLE TUBE  
REV. B  
SHEET 1 OF 3  
SCALE NTS

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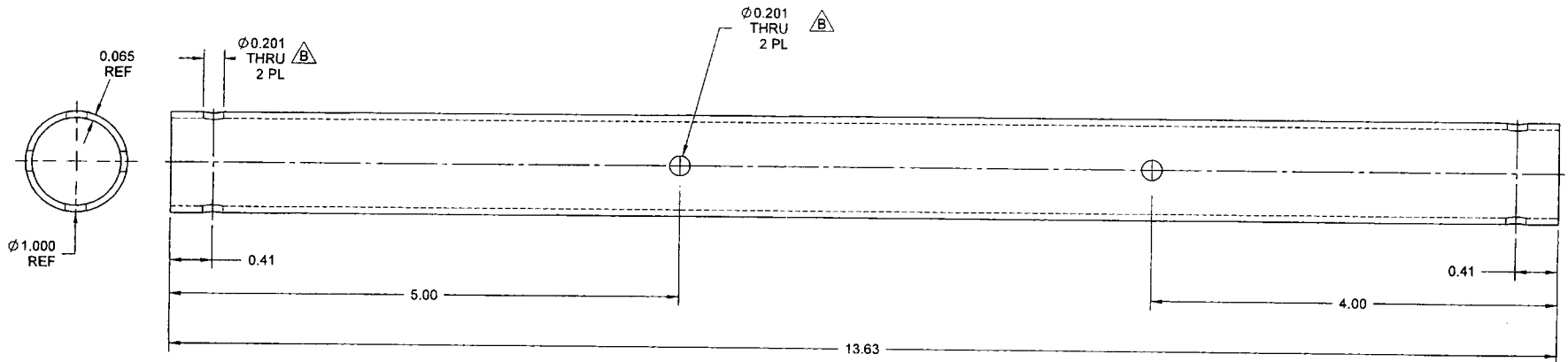
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**NOTE:** Date & initial all entries



86130



**D3770-1 TUBE**

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08.07.10

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MFG. APPR.		<b>D3770</b>	SHEET 2 OF 3
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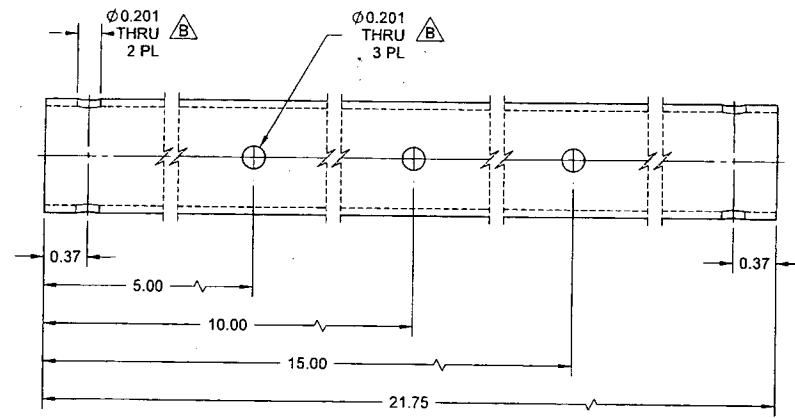
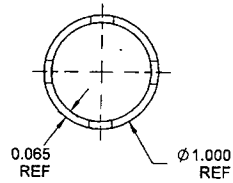
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05.07.10

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MFG. APPR.	MS	<b>D3770</b>	SHEET 3 OF 3
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